

Date: Friday, 1/25/2008 10:50:35 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY RH (206/407)
Job Number : 36966A
Estimate Number : 11775
P.O. Number :
This Issue : 1/25/2008 S.O. No. :
Prsht Rev. : NC Part Number : D2842042
First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2842 REV B
Previous Run : 36493A Material :
Written By : Due Date : 3/10/2008 Qty: 6 Um: Each
Checked & Approved By :
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 36923
37754 (6)

Check Material for any Dents or Defects

SAD

08/04/28

(6)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8272 as per Dwg D2842

3-Deburr and bevel ends for welding

SAD

08/04/28

(6)

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch:
2 D2734 End Cap 336520

08.04.29 6

4.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

plate

Batch: 331346

08.04.29 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:50:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 36966A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34593

plate



No more

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

plate

Batch:

337347 = 8

337789 = 4

337349 = 4

08.04.29

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R

AL Rod

Batch:

M106762
M106834

M107678

2-Grind end cap weld flush

08.04.30

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.05.06

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

08.05.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 36966A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

✓ A/R AL Rod Batch: M106834

2-Grind end cap weld flush.

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M106951

17.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M107008 OK

18.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

M107394

30 min
13/05/2008
S.240 11.48
#1 318.8 F
#2 D2842042 F
#3 B36966A. F
#4

08-05-12 6

PD 08-05-13 6

08/05/13 6

FA 08/05/13 6

BR 08-05-03 6

BR

BR

BR

BR 08-05-14 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36966A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10L

WASHER

M107939

BL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

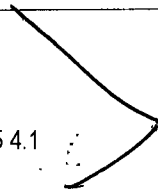


Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: *M107380*



BL 08-05-14 (6)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BL 08/05/14 (6 RH)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 36966

8/5/14

(2)

SV

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/14

Job Completion



MF 08-05-15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

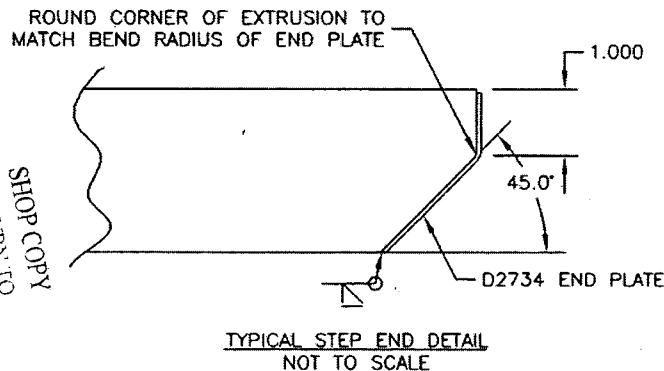
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. 8
CHECKED 	APPROVED 	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23	TITLE 206L/407 FLOAT STEP ASSEMBLY		SCALE NTS	
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		



QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AES510KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

RELEASED
8-11-14

- D2842-041/-042 FLOAT STEP ASSEMBLY** NOT TO SCALE
- 1) MAKE FROM EXTRUSION D2622
 - 2) WELD PER DART QSI 004
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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